

Wednesday, 4/16/2008 9:56:54 AM
Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
 Job Number : 35854
 Estimate Number : 11139
 P.O. Number :
 This Issue : 4/16/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D32051
 First Issue : 11/19/2007 Type : MACHINED PARTS Drawing Number : D3205 REV A
 Previous Run : 34238 Drawing Revision : A
 Material :
 Due Date : 12/6/2007 Qty: 12 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est A 04.06.09 New issue KJ/RF

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M7075T73B2500X0325	7075-T73 Bar 2.5 x 3.25"
-----	--------------------	--------------------------



Comment: Qty.: 0.3828 f(s)/Unit Total: 4.5940 f(s)

7075-T73 Bar 2.5 x 3.25"

Material: 7075-T73 (QQ-A-200/11 or QQ-A-250/12) or 2024-T3 (QQ-A-200/3 or QQ-A-250/4)

(M7075T73B2.500x03.25)

Identify for D3205-1

Batch: 102694

SA

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks: 3.250" x 2.500" x 4.250" long Bar (+0.030/-0.000)

SA 08/04/18

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Machine D3205-1 as per Folio FA346 and Dwg D3205

Identify as D3205-1

Deburr and Tumble

HA/SA

08/04/18

PTO

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HA/SA

08/04/18

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SA 08/04/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3205-1 PAR #: N/A Fault Category: Rolling Condition NCR: Yes No DQA: D Date: 08/04/24
D412-704-041 QA: N/C Closed: D Date: 08/04/24

NCR: <u>358547</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/17	30	multiple Errors in the program #4000, #	<i>[Signature]</i>	SCRAP & Replace. Fix Program & Attach program self-checkment copy.	08/04/21	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 35854

Part Number: D32051

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-04-23

(12)

30 min.

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Note: Cover the thread hole for D3205-1 before powder coat.

BR 08-04-23

23/04/2008
S.096 11.36
#1 317.1
#2 35854
#3 D.32051

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-A 08/04/23

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 200

AS 08/04/23 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/24

Job Completion



h 08-04-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 35854
Description: Pedal Bracket		Part Number: D3205-1
Inspection Dwg: D3205 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.100	+/-0.010	1.106	✓			
0.250	+/-0.010	0.254	✓			
R0.37	+/-0.030	R0.37	✓			
0.125	+/-0.010	0.133	✓			
0.250	+/-0.010	0.258	✓			
2.380	+/-0.010	2.381	✓			
1.380	+/-0.005	1.3805	✓			
0.500	+/-0.005	0.497	✓			
0.880	+/-0.010	0.8825	✓			
Ø0.470 x 100°	+0.005/-0.000	Ø0.473 x 100°	✓			
0.440	+/-0.005	0.445	✓			
0.600	+/-0.005	0.605	✓			
1/4-28UNF-313	N/A	1/4-28 UNF	✓			
0.250	+/-0.010	0.247	✓			
Ø0.257	+0.005/-0.000	Ø0.258	✓			
1.750	+/-0.010	1.7545	✓			
0.870	+/-0.005	0.8705	✓			
0.440	+/-0.005	0.4445	✓			
R0.25	+/-0.030	R0.25	✓			

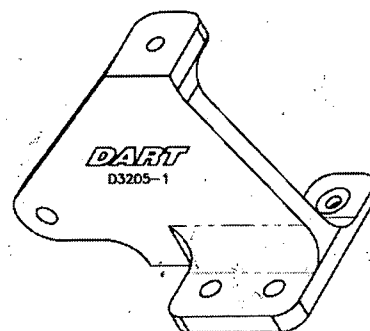
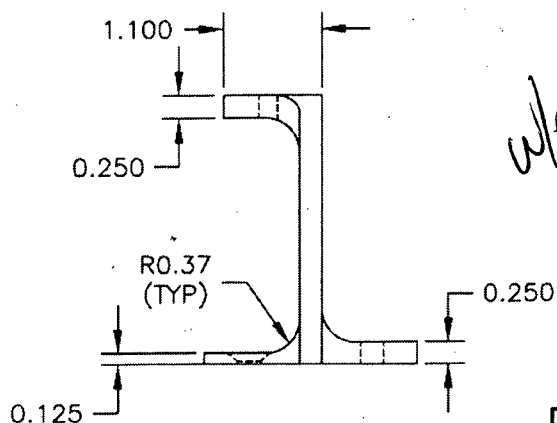
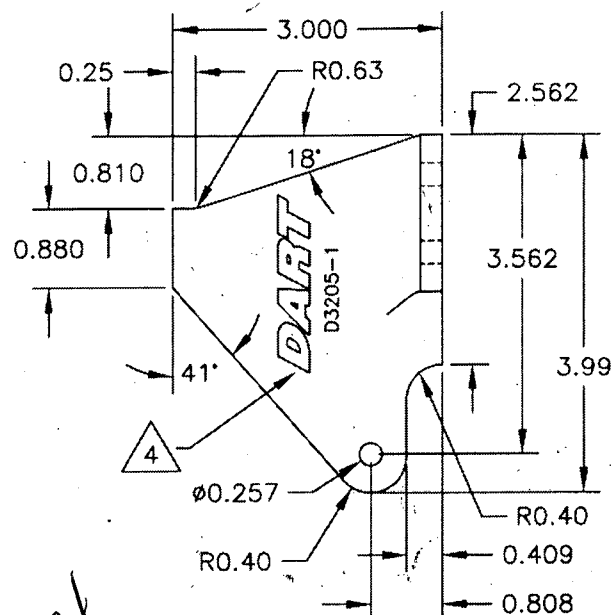
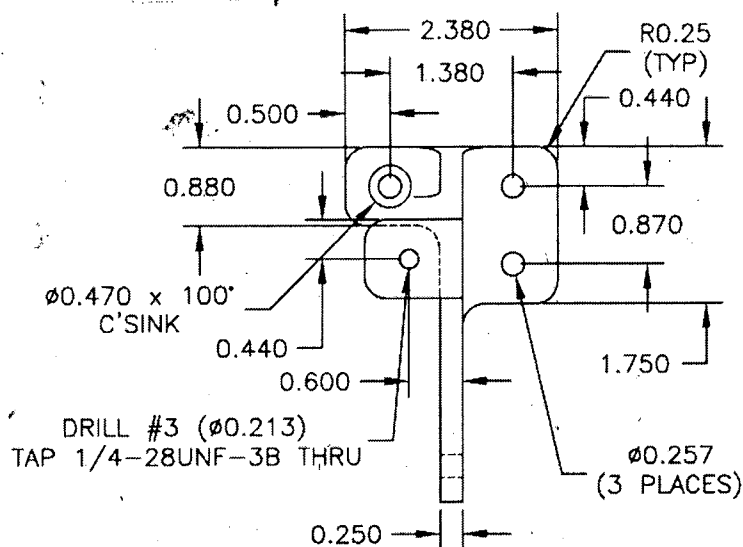
Measured by: H.A./CNR	Audited by: DFP	Prototype Approval:	N/A
Date: 08/04/18	Date: 08/04/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	



DESIGN 14	DRAWN BY 14	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3205	REV. A SHEET 1 OF 2
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04-04-05 #



D3205-1 PEDAL BRACKET

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
2) MATERIAL: 7075-T73 (QQ-A-200/11 OR QQ-A-250/12)
OR 2024-T3 (QQ-A-200/3 OR QQ-A-250/4)
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
4) ENGRAVE DART P/N & LOGO AS SHOWN
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE INCHES

Copyright © 2004 by DART AEROSPACE LTD

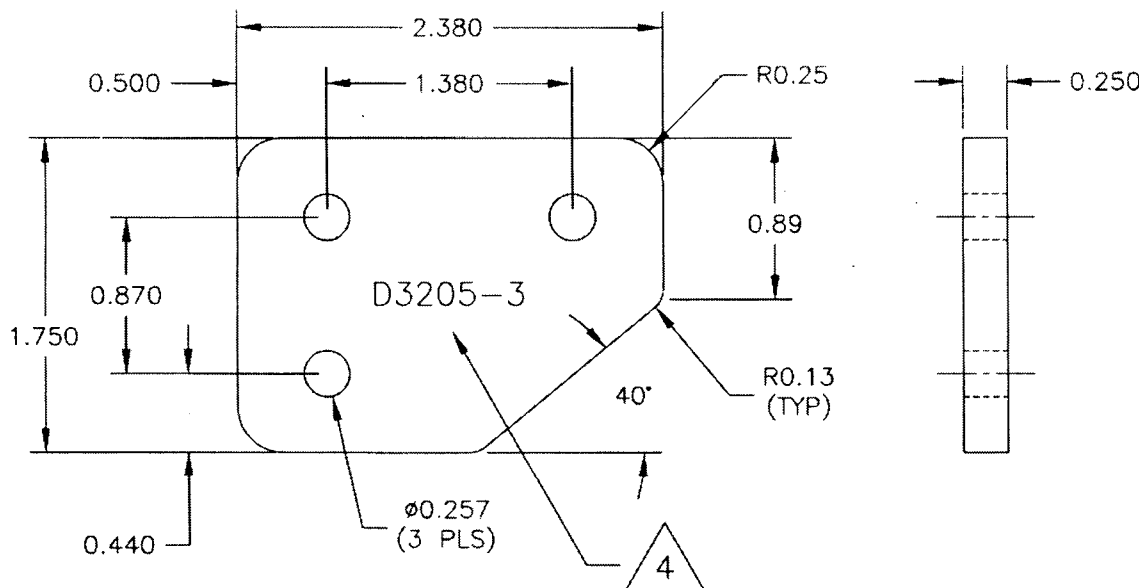
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
13	13	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
13	13	D3205
DATE	TITLE	REV. A
04.01.27	BRACKET	SHEET 2 OF 2
		SCALE 1:1

RELEASED
04.04.03



D3205-3 BACK PLATE

W/o 35854

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

PROGRAM MODIFICATION FOR PART NUMBERS

PART NUMBER: <u>D3205-1.</u>			
Program Number	NCC File	Tool Number	Mod. to be Preformed & Operation Description (Specify Line #)
A346AA03. #300	A34AA03.NCC	T16	Prog Called T6 instead of T16

Requested By: Carl. Aucklin

Done By: [Signature] 08.04.21.

%
O4000
(A346AA04.NCC 05-01-17 12:40)
G17 G80 G40 G90
(CENTER DRILL TAPPED HOLE)
(T1-#4 CENTER DRILL .150" DEEP)
N1 T1 M06
N2 S1500 M03
N3 M08
N4 G0 G57 X.44 Y-.6
N5 G43 H01 Z1.2
N6 G81 G98 X.44 Y-.6 Z-.15 R.15 F12.
N7 G80
N8 G0 Z1.2
(TAP DRILL FOR 1/4-28NF)
(T5-#3 DRILL .350" DEEP)
N9 T5 M06
N10 S4000 M03
N11 M08
N12 G0 G43 H05 Z1.2
N13 G81 G98 G57 X.44 Y-.6 Z-.35 R.15 F11.
N14 G80
N15 G0 Z1.2
(TAP 1/4"-28NF)
(T9-1/4-28" NF TAP .350" DEEP)
N16 T9 M06
N17 S450 M03
N18 M08
N19 G0 G43 H09 Z1.2
N20 G84 G98 G57 X.44 Y-.6 Z-.35 R.15 F16.07
N21 G80
N22 G0 Z1.2
(SPOT DRILL .470" DIA)
(T16-1/2-100 DEG SPOT DRILL .1972" DEEP)
N23 T16 M06
N24 S2500 M03
N25 M08
N26 G0 G57 X-.37 Y-.815
N27 G43 H16 Z1.2
N28 G81 G98 X-.37 Y-.815 Z-3.0722 R-2.725 F15.
N29 G80
N30 G0 Z1.2
G00 G49 G90 Z0.0 M9
G28 G91 Y0.0 Z0.0
M30
%